

Date: Wednesday, 12/11/2008 1:40:34 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 43374	Part Number	: D2596
Estimate Number	: 10346	Drawing Number	: D2596 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 12/11/2008	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 19/11/2008
Previous Run	: 43250	Qty:	16
Written By	:	Um:	Each
Checked & Approved By	: <u>JUL 08-11-12</u>		
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Extrn -'I' Beam Web 4"	16Pcs
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) Extrusion "I" Beam Web 4"	
		Pick: Qty Part Number Description Batch	AWM 8-11-13
1	D2500-3-100	Extrusion	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	16Pcs
		Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr	AWM 8-11-13
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	16Pcs
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	AWM 8-11-13 16Pcs
4.0	QC5	INSPECT WORK TO CURRENT STEP	8- 11- 13 16
		Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Skidtubecell

DP 8-11-13 16

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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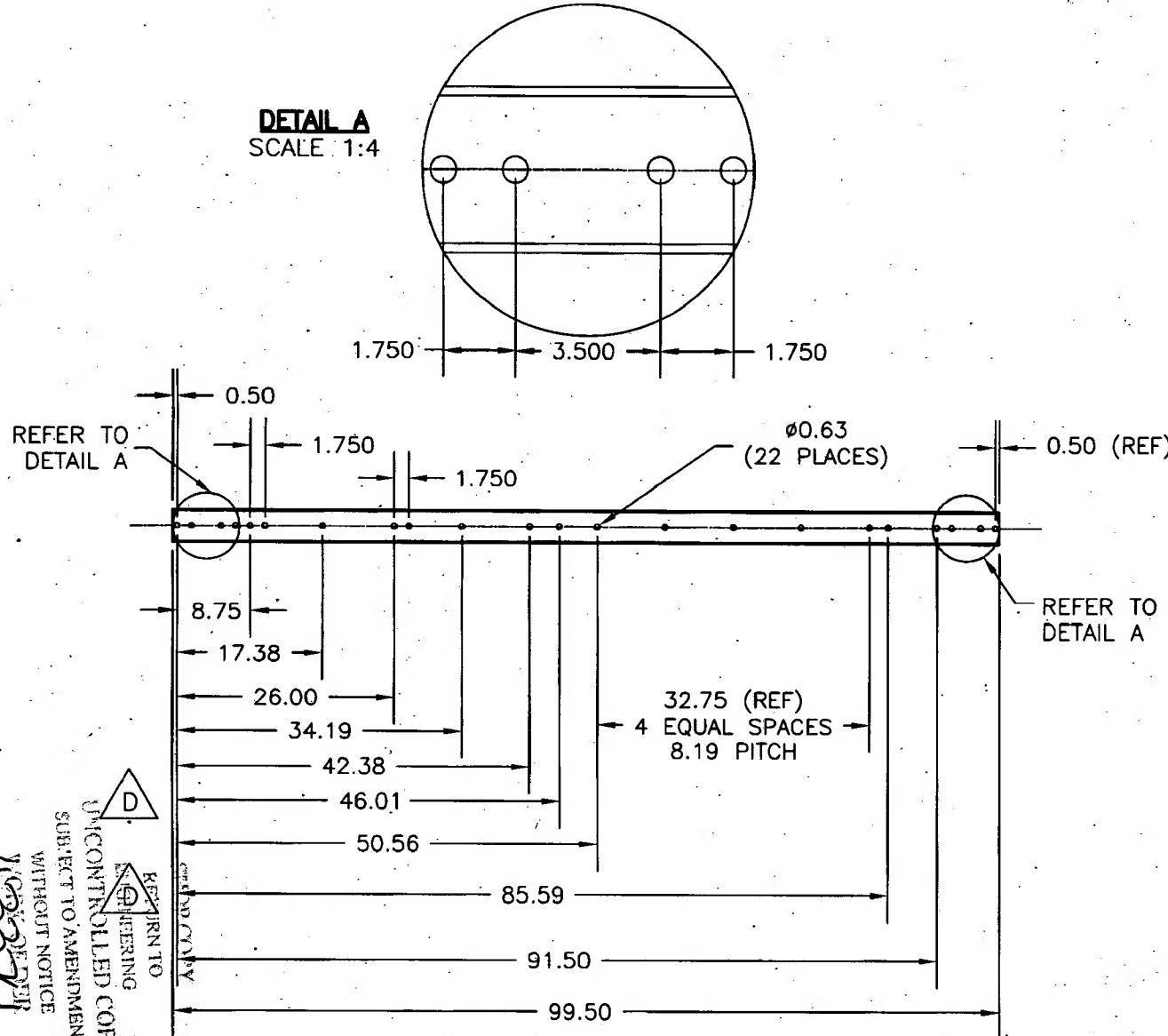
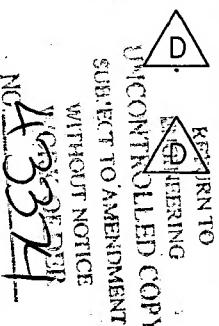
NOTE: Date & initial all entries

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D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) DEBURR SHARP EDGES 0.010 TO 0.020



**RELEASED
07-08-28**

11

1

		DRAWN BY	
<i>RH</i>		<i>RH</i>	
CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17	TITLE 205 WEB	SCALE 1:20	
A	96.09.16 NEW ISSUE		
B	97.07.23 Ø0.63 HOLE WAS Ø0.56		
C	98.09.14 INCORPORATED DEO 9097		
D	07.04.17 INCORPORATED DEO 9183		